

Date: Thursday, 2/14/2008 2:21:00 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HI-STEP LEG ASSEMBLY
Job Number : 37452	
Estimate Number : 10355	
P.O. Number :	Part Number : D2582
This Issue : 2/14/2008 S.O. No. :	Drawing Number : D2582 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 36710	Material :
Written By :	Due Date : 2/25/2008 Qty: 12 Um: Each
Checked & Approved By : <u>08 02 14</u>	
Comment :	
Est Rev:F Removed Manufacturing 05-11-07 JLM	
Est Rev:G Added part # to Sub 06-08-10 JLM	
Est Rev H New pick list 08.01.11 EC	
verified by: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	37452A	STEP LEG
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Comment: Sub-Component STEP LEG

D2278 B 37452A

mf

2.0	37452B	STEP SPACER
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Comment: Sub-Component STEP SPACER

D2322 B 37452B

mf

3.0	37452C	STEP SPACER
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Comment: Sub-Component STEP SPACER

D2279 B 22585

mf

4.0	37452D	STEP SPACER
-----	--------	-------------



Comment: Sub-Component STEP SPACER

D3720-1 B 37452D

mf

5.0	37452E	STEP SPACER
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Comment: Sub-Component STEP SPACER

D3720-2 B 37452E

mf

08-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 08/03/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 37452

Part Number: D2582

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 22.0000 Each(s)/Unit Total : 264.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 MS20470AD4-4 Rivet M106654

mf

7.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS20470AD4-5 Rivet M104156

mf

08-03-06

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2582 and

mf

08-03-06

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/06 (12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA27

PE

08-03-06

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/06

Job Completion



mi 2008/3/06

(12)

Dart Aerospace Ltd

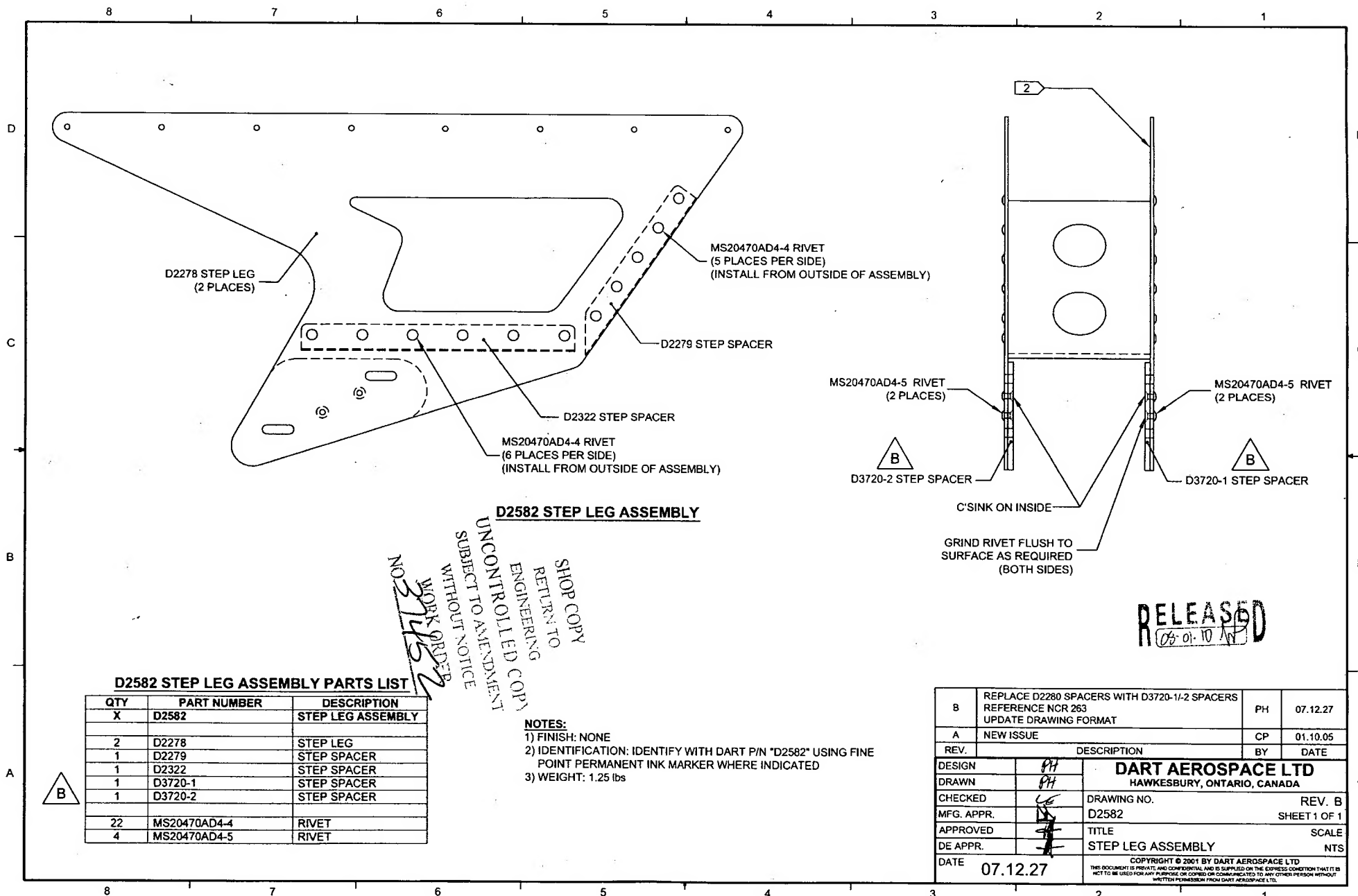
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries



Date: Thursday, 2/14/2008 2:21:01 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP LEG
Job Number	: 37452A		
Estimate Number	: 10353		
P.O. Number	:	Part Number	: D2278
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D2278 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: F
Previous Run	: 36710A	Material	:
Written By	:	Due Date	: 2/25/2008 Qty: 24 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 05-11-07 JLM		
	: Est Rev:B Now 6061-T6 06-06-23 JLM		
	: Est Rev C New flat pattern 08.01.11 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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32



Comment: Qty.: 1.0306 sf(s)/Unit Total : 24.7338 sf(s)
Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick
(M6061T62S.080)
Identify as D2278
Batch: 107276 IB 8-3-3

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D2278
Dwg Rev: F
Prog Rev: F

IB 8-3-3

(31)

2-Deburr if necessary IB 8-3-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-3-3



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



counts

Comment: SECOND CHECK

✓ order log (31)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 15 Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 37452A

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

4/

08-03-04

(V3)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf

08-03-06

(31)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf

08-03-06

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(31)

Comment: FINAL INSPECTION/W/O RELEASE

20080306

Job Completion



in 2008/3/06

(31)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/11 OR (REF DART SPEC M6061T6S.080)
OR
5052-H32 ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/8 OR AMS 4016) (REF DART SPEC M5052H32S.080)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

NO. 37452A
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

F	CHANGE 00.213 H.O. ES. TO 00.213 X.0.750 SL.OT CHANGE SOME DIMENSIONS TO XXX FROM X.XXX UPDATE PROFILE AND FORMAT. REF. NCR 263	PH	07/12/27
E	ADD 6081-16 MATERIAL	CB	06/05/29
D	ADD FINISHING NOTE	PH	05/11/14
C	CHANGED RADIUS TO 0.354	BW	95/02/16
B	CHANGED TO MATCH SPACERS	BW	94/11/08
A	NEW ISSUE	BW	94/10/13
REV.	DESCRIPTION	BY	DATE
DRAWN	<i>AW</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AW</i>		
MFG. APPR.	<i>AW</i>		
APPROVED	<i>AW</i>		
DATE	07.12.27	LEG	SCALE
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DRAWING NO. D2278 SHEET 1 OF 1		REV. F SCALE	
3.2:2			

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JUL 01 1974

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